

Work Order ID 53893

November 23, 2009 11:25:32 AM

Page 1

Item ID: D3646-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Arm

Start Date: 23/11/2009 Start Qty: 6.00

Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3646

Rev A

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959

⇒ m-l 10/02/18

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- Bend as per dwg D3646

⇒ m-l 10/02/24

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/25

6x

6x

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3646-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Arm					
Start Date:	23/11/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QS1005 4.3 M105642 Memo START TIME: 1:30pm 2:00pm FINISH TIME: 3:20pm OVEN TEMPERATURE:	0.00 0.00							
						X6			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
						X6			
150 Packaging Packaging	Identify as per dwg & Stock Location: 229 Memo	0.00 0.00							

210/3/01 6

W/O:		WORK ORDER CHANGES					
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Item ID: D3646-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/02

MF

10-3-01

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November 23, 2009 11:25:38 AM

Page 1

Work Order ID: 53893



Parent Item: D3646-3RevA



Parent Item Name: Arm

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	226.0709	18.3789			
304 RD Tube .500 x .035W												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

226.0708674

108250

2.23

111704

31.6682737

112187

43.9830937

112800 ✓

148.1895

M-L
18.3789 10/02/18

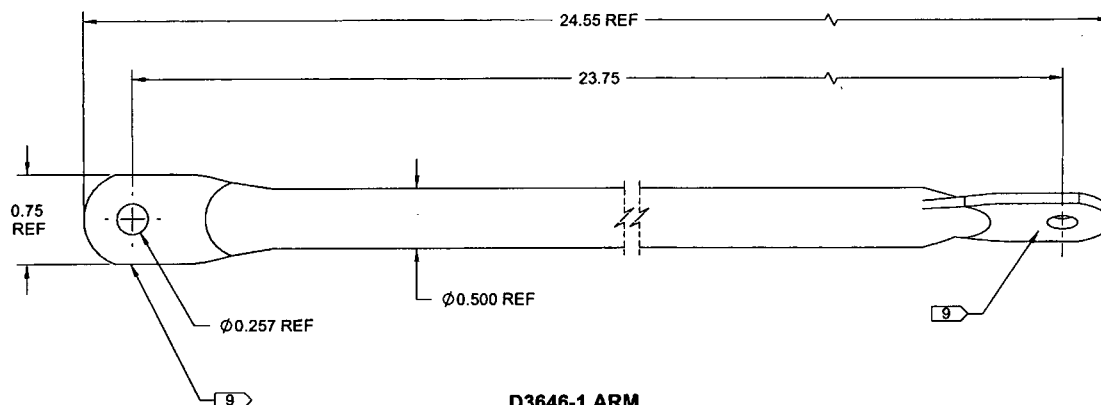
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3646-1 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500$ X 0.035 WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. 53893
09-11-23

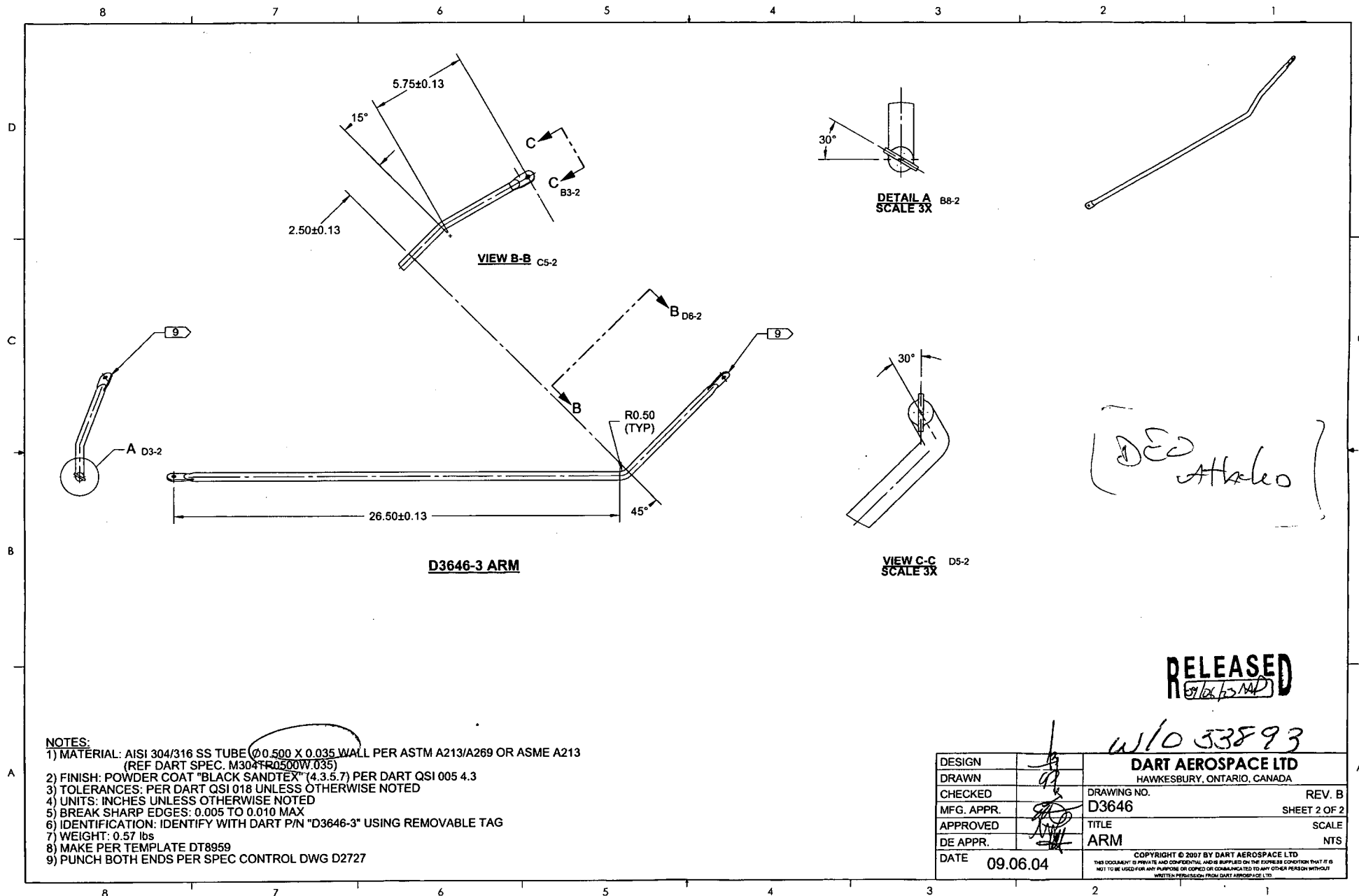
RELEASED
09/18/23 M7

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3646** REV. B
TITLE **ARM** SCALE NTS
SHEET 1 OF 2

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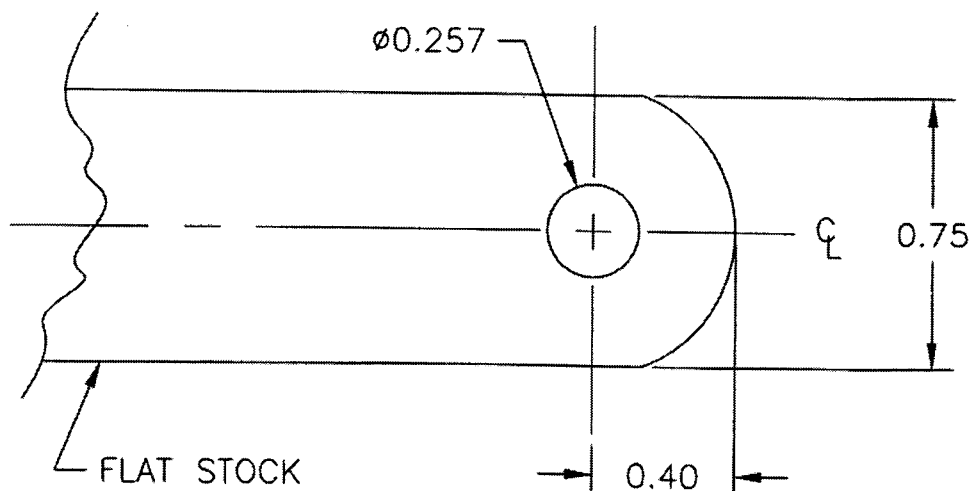
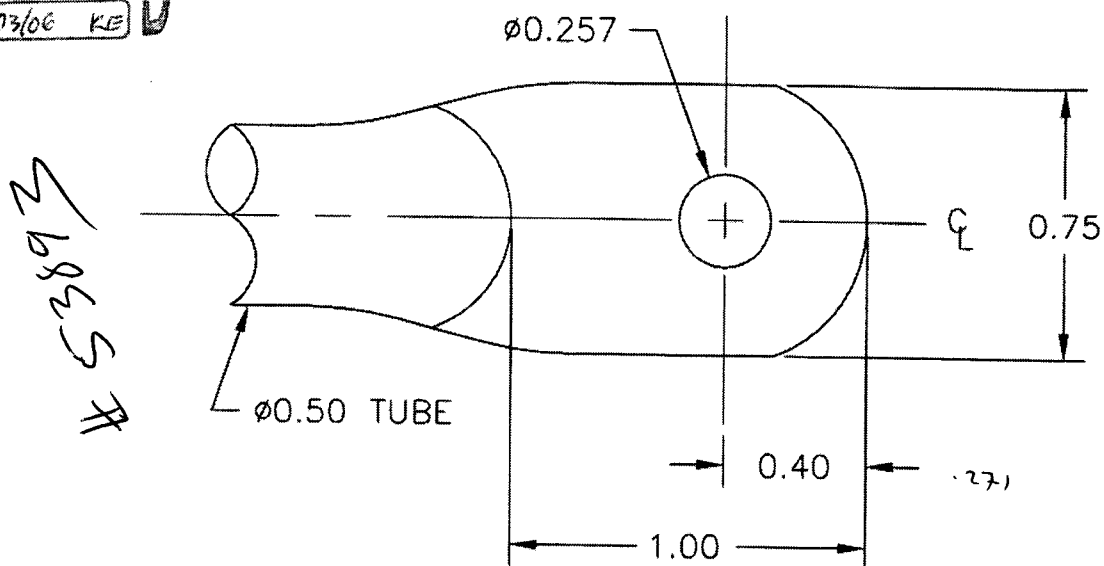




DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#10 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



Dart Aerospace Ltd

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